

January-17-12 9:02:09 AM

78923

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

40

40

Reference:

Date:

Run Start *NR1*

Date:

Stop *NR2*

Draw Nbr	Revision Nbr
D3414	Rev C

0.00

100

Memo

0.00

Cut blanks: 2.50" x 0.500" x 2.250" long

0.00

110

Memo

0.00

Machine as per Folio FA569 and Dwg D3414
Identify as D3414-3Dwg Rev C Folio Rev AA

0.00

120

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78923

78923

Page 2

January-17-12 9:02:09 AM

Item ID: D3414-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 17/01/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	Ba	12/02/12		40	0		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo	0.00 0.00				EL	12-2-14	X40	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Handwritten: M.C.S 12/02/14
 (40)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-17-12 9:02:13 AM

Page 1

Work Order ID: 78923

78923

Parent Item: D3414-3

D3414-3

Parent Item Name: Lug

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	44.9970	0.1875	7.5			

M304B0 500X2 500

304 BAR .500 x 2.50

Location

Loc Qty

Loc Code

MAT050

44.997

112764

8.312

116135

0.375

117685

4.4

~~119231~~

31.91

8.5

36 12/02/12

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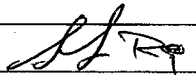
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	78923
Description: Lug		Part Number:	D3414-3
Inspection Dwg: D3414 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	Ø0.515	✓		SLO8	View
2.07	+/-0.030	2.068	✓		Height Gauge	
1.99	+/-0.030	1.990	✓		SLO8	View
1.30	+/-0.030	1.302	✓		"	
1.12	+/-0.030	1.1215	✓		"	
0.38	+/-0.030	0.378	✓		"	
0.060	+/-0.010	0.065	✓		"	

Measured by: 	Audited by: B.A.	Prototype Approval:	N/A
Date: 12/02/11	Date: 12/02/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.14	New Issue	KJ	
B	09.11.12	Dwg Rev updated	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

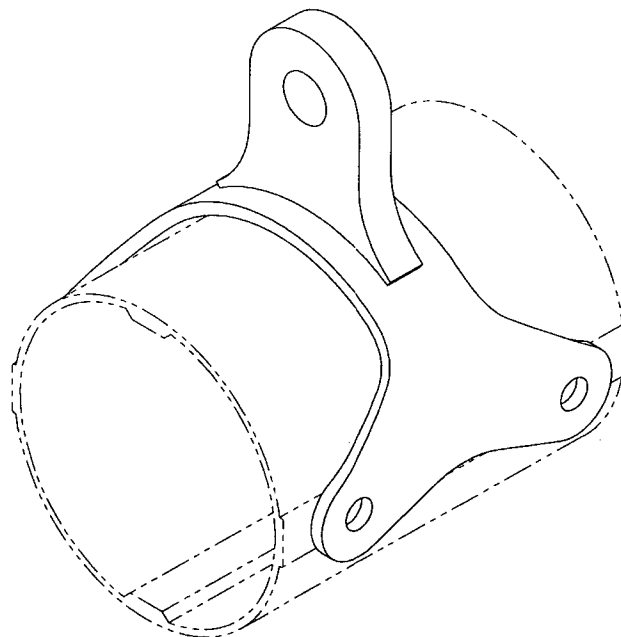
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
RETURN TO
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO REVISION
WITH THE
WORK ORDER

NO. 78923 M.C.J
12/01/17

RELEASED
09/06/17

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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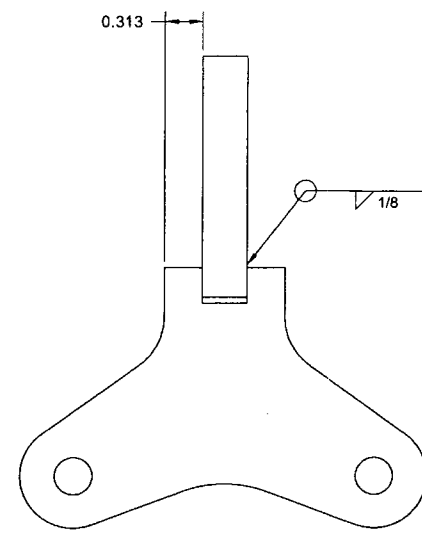
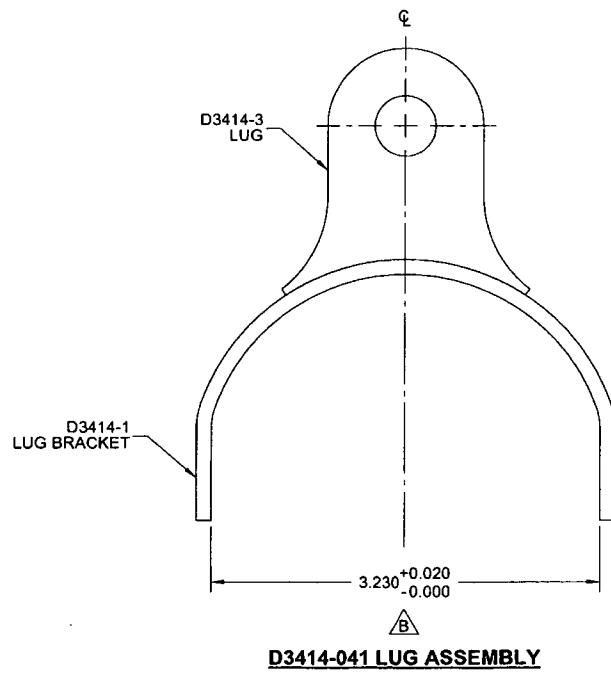
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NOTE: Date & initial all entries

78923



RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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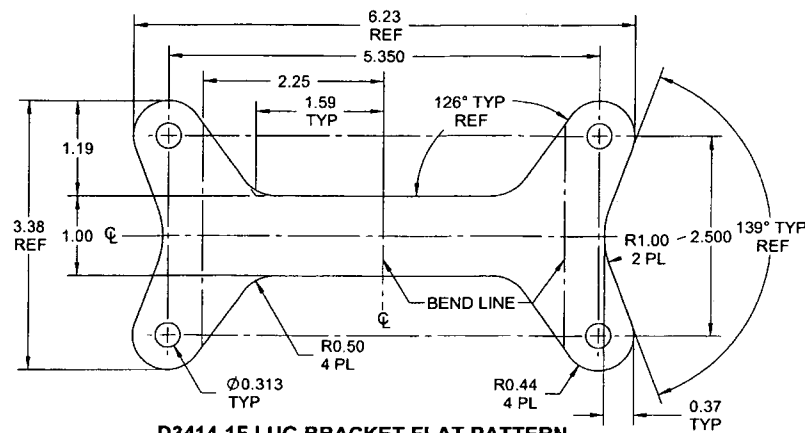
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

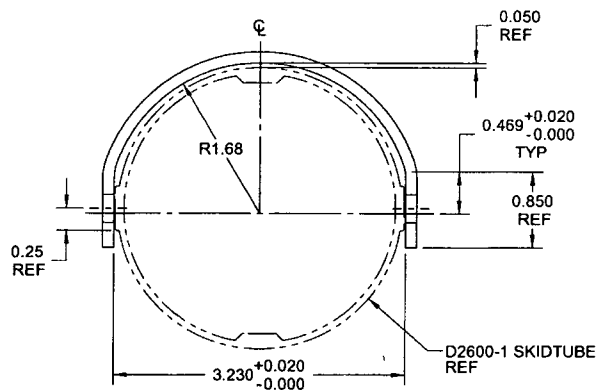
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NOTE: Date & initial all entries

78923



D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

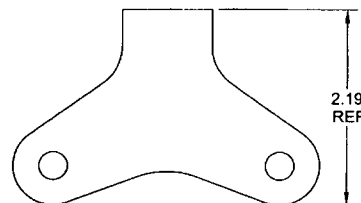
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

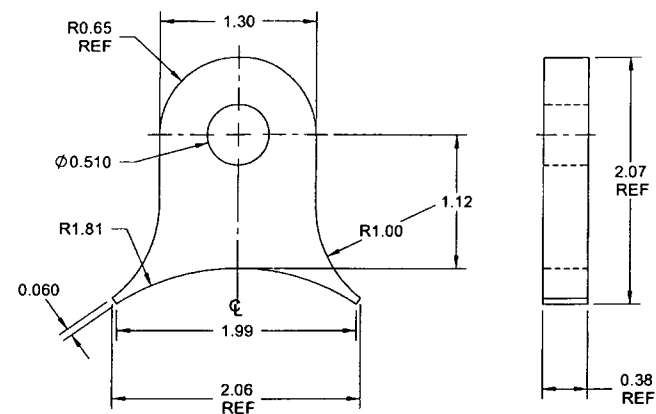
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG

RELEASED

DESIGN	OP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OP		
CHECKED	OP	DRAWING NO. D3414	REV. C
MFG. APPR.	OP	SHEET 3 OF 3	
APPROVED	OP	TITLE	SCALE
DE APPR.	OP	LUG ASSEMBLY	NTS
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